

Work Order ID 86652

86652

Page 1

July-06-12 11:12:35 AM

Item ID: D3189-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chafing Shield

Start Date: 7/06/12

Start Qty: 30.00

30

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date: 12076

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3189	Rev B

100

0.00

100

~~SHEAR~~

Waterjet

Memo

0.00

FLOW CNC Waterjet.

304 - 020

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

30

0

Jm 12-7-17

7107

103

QC2- Inspect parts off machine FAI/FAIB

0.00

103

QC

Memo

0.00

Quality Control

30

0

Jm 12-7-17

W/O: 86652		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3189-1 PAR #: _____ Fault Category: Water / etc NCR: Yes ☒ No ☐ DQA: 12/17 Date: 12/08/01
 Resolution: _____ Disposition: Scrap QA: N/C Closed: 12/18/02 Date: 12/18/02

NCR: 12-1641		WORK ORDER NON-CONFORMANCE (NCR) 11.55 x 3 = 34.65						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/17	#100	Qty x3 parts found to be 4.010 instead of 4.130. P.C. was cut too close to edge of sheet - operator error	DAS 15 2-09 02/07 12/19/17	Scrap + Destroy no Replen Qty x3	JM 12-7-17	D 16 2-09 0 12/19/17	DAS 16 2-09 02/07 12/19/17	DAS 16 2-09 12/19/17

NOTE: Date & initial all entries

Work Order ID 86652

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Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chafing Shield
Start Date: 7/06/12 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 7/27/12 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>228</u>	<u>23</u>		
110 *110* Small Fab Small Fab	Small Fab Memo 1- Roll as per Dwg D3189 2- Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DSI9549 and DEO D412-664-243. 121710	0.00 0.00				<u>28</u>	<u>0</u>		FF 12-07-19
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							12-7-19 (28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86652

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July-06-12 11:12:35 AM

Item ID: D3189-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Chafing Shield

Start Date: 7/06/12 Start Qty: 30.00

30

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: LG52

0.00

130

Packaging

Memo

0.00

Packaging

12

12 - 7 - 30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/31

12/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:12:34 AM

Page 1

Work Order ID: 86652
 Parent Item: D3189-1
 Parent Item Name: Chafing Shield

Start Date: 7/06/12 Required Date: 7/27/12
 Start Qty: 30.00 Required Qty: 30.00

Comments: IPP B05.08.22No longer made in-houseKJ/JLM
 IPP Rev:C 06-03-24 Rolling Now made in House JLM
 IPP Rev:D 07-04-16 As per Rev B JLM
 waterjet DD verf:JLM
 IPP Rev:E 11.05.11 now made on

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 304/316 .020" Sheet		Purchased	No			100	sf	64.6000	0.32	10.105265 10.5			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT020				64.6					
				118228				64.6		<u>118228</u>			Jan 12 7-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

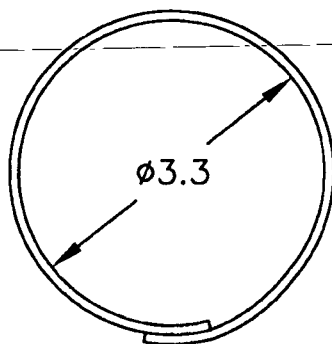
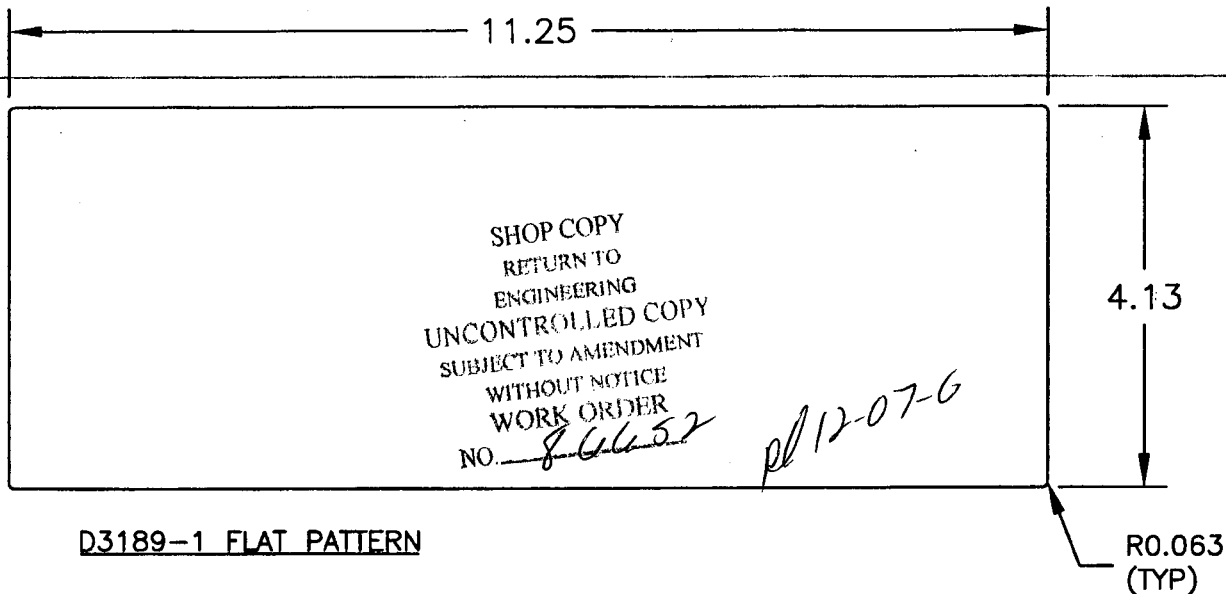
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED
07 03 27 *[initials]*



D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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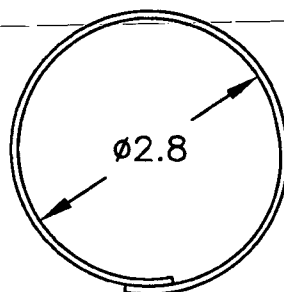
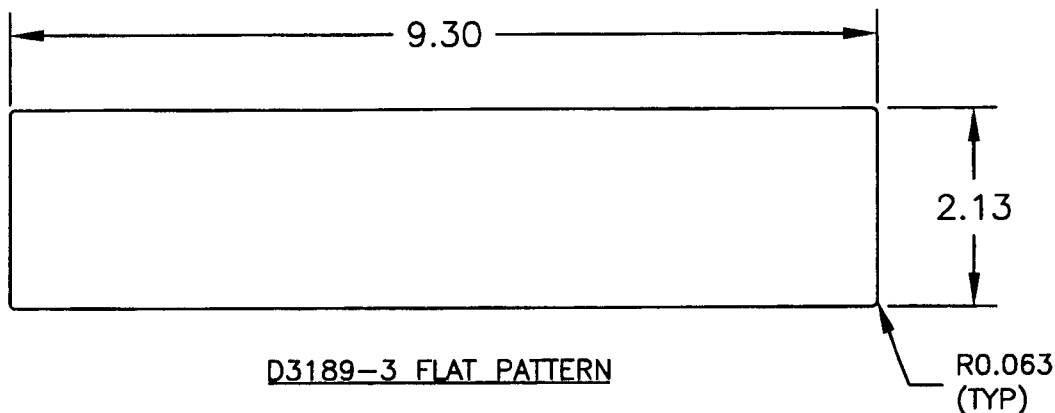


DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 *[Signature]*

86657



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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